Work Order ID 112204 \*112204\* Page 1 January-30-14 11:17:13 AM Accept **Item ID:** D3505-1 \*N900040100\* Setup Start **Revision ID:** Item Name: Web \*10\* **Start Qty: 10.00 Start Date:** 1/30/14 **Cust Item ID:** Required Date: 1/30/14 Req'd Qty: 10.00 \*10\* **Customer:** Reference: Start Run Process Plan: MLJ Date: 14-01-31 Tooling: Date: **Approvals:** Stop Date: SPC (Y/N): Date: Operation Set Up/ Tool ID Tool # Plan Reject Reject Insp. Sequence ID/ Accept Qty **Work Center ID Description Run Hours** Code **Qty** Number Stamp **Draw Nbr Revision Nbr** D3505 Rev A 100 0.00 10 d 14-2-25 i Skidtubes \*100\* Skidtubes 0.00 Memo 1-Cut to Lengh as per Dwg D35052-Drill Pillot Holes using DT8869 Drill Skidtubes Jig3-Open pillots to 1.000" as per Dwg D35054-Deburr DAS 0.00 110 QC5- Inspect part completeness to step on W/O \*110\* OC Memo **Quality Control** Chemical Conversion Coat per QSI005 4.1 0.00 120 10 9 14-2-27 DGC \*120\* 0.00 HandFinish

Memo

Hand Finishing

DQA:		Date:				•	TRAG								
			WORK ORDER NON-	AEROSPACE											
QA Closed: Date:															
Work Order:				DISPOSITION			A	PARTMENT/PROCESS			:				
	•				_	Rework		Skid-tube Crosstube			Water Jet			Engineering	
Part I	No.					Scrap		Machining Small Fab			Prod. Eng. Coor.		٦	Quality	
	•		<del></del>		_	Use-as-is		Thern	Thermoforming Finishing		Rec/Store/Packaging		٦	Other	
NCR I	۷o.				'	Suspected Unapproved		Large Fab Composite		mposite	Supplier				
Root					Desc	cription of work order update		nitial	Action		Sign &				
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description	n	Date	Verification		QC Inspector	
Design															
Doc/Data															
Equip/Tooling													١		
Handling/Pre													1		
Material													1		
Operator															
Offset/Setup															
Process	igsqcup				:								١		
Supplier															
Training .							l						l		
Transport	<u> </u>														
Unapproved			L	<u> </u>			<u> </u>								
							FAI	ULI CA	TEGORY						
Landi	ng (	1				General	_	111-7	<b>.</b>		امسيار م		_	D /5	
		Bending		. 41	-	Bend		Folio/Program			Outside Dimensions			Pressure/Forced	
•	$\vdash$	Centre Not Concentric		-	BOM/Route		Grain			Over/Under tolerance		_	Set-up		
	Cracks			/\.	$\vdash$	Broken/Damage/Defect		Hardware			Part Incorrect			Temperature/Cure	
	Crimp/Kink/Ripple/Wave			Burrs			nspection Incomplete/Unqualified		Part Lost/Missing		$\dashv$	Weld			
·	Custing			$\vdash$	Countarion	<u> </u>	4	tions Incomplete/Unclea	<sup>3r</sup>	Part Moved			Wrong Stock Pulled		
	Crushing			$\vdash$	Countersink Cut Too Short	⊢	1	gned/off center		Positioned W Power Loss/S		$\neg$	Other		
	Heat Treat			Tuba	 	4						ourge		Other	
·	Inspection Strip in Tube Marks/Chatter			odui	$\vdash$	Drawing Drill Holes		Misrea Off-set							
	-	1			-		-	4							
	$\vdash$	Turning S	•		-	Finish	$\vdash$	1	Calibration						
	Wave/Twist in Tube				Fit/Function	1	JOUT OF	Sequence							

Work Order ID 112204 \*112204\* January-30-14 11:17:13 AM Item ID: D3505-1 Accept Setup Start \*N900040100\* **Revision ID: Item Name:** Web \*10\* **Start Oty: 10.00 Start Date:** 1/30/14 **Cust Item ID:** Req'd Oty: 10.00 Required Date: 1/30/14 \*10\* **Customer:** Reference: Start Run **Process Plan: Tooling: Approvals:** Date: Date: Stop Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Accept Reject Reject Qty Qty Number Stamp **Work Center ID Description Run Hours** Code QC7-Inspect Chemical Conversion Coat 0.00 130 \*130\* OC 0.00 Memo Quality Control

140 \*140\*

Identify as per dwg & Stock Location: 46

Memo

0.00

0.00

14-2-27 DGC

OC21- Final Inspection - Work Order Release 0.00

\*150\*

QC

Memo

0.00

MF-2-27

Page 2

Insp.

Packaging

Packaging

150

**Quality Control** 

DOA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** Work Order update only QA Closed: Date: DISPOSITION AGAINST DEPARTMENT/PROCESS Work Order: Skid-tube Engineering Crosstube Water Jet Rework Small Fab Prod. Eng. Coor. Quality Machining Part No. Scrap Thermoforming Finishing Rec/Store/Packaging Other Use-as-is NCR No. Suspected Unapproved Large Fab Composite Supplier Description of work order update Initial Action Sign & Root or non-conformance Chief Eng Description Date Verification **QC** Inspector Date Qtv Cause Step Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved **FAULT CATEGORY** General **Landing Gear** Bend Folio/Program **Outside Dimensions** Pressure/Forced Bending BOM/Route Set-up Centre Not Concentric Grain Over/Under tolerance Broken/Damage/Defect Cracks Hardware Part Incorrect Temperature/Cure Crimp/Kink/Ripple/Wave Inspection Incomplete/Unqualified Part Lost/Missing Weld Burrs Wrong Stock Pulled Cuffs Instructions Incomplete/Unclear Part Moved Contamination Misaligned/off center Countersink **Positioned Wrong** Crushing

Mislabeled

Out of Calibration

Out of Sequence

Misread

Off-set

**Cut Too Short** 

Drawing

Finish

**Drill Holes** 

Fit/Function

Other

Power Loss/Surge

Marks/Chatter

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

## **Picklist Print**

January-30-14 11:17:12 AM

Work Order ID:

112204

Parent Item:

D3505-1

**Parent Item Name:** 

Web

**Start Date:** 1/30/14

Required Date: 1/30/14

Page 1

Start Qty: 10.00

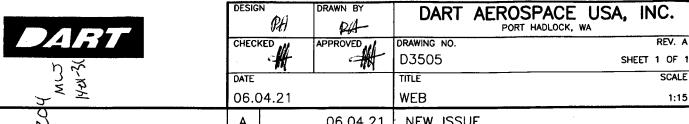
Required Qty: 10.00

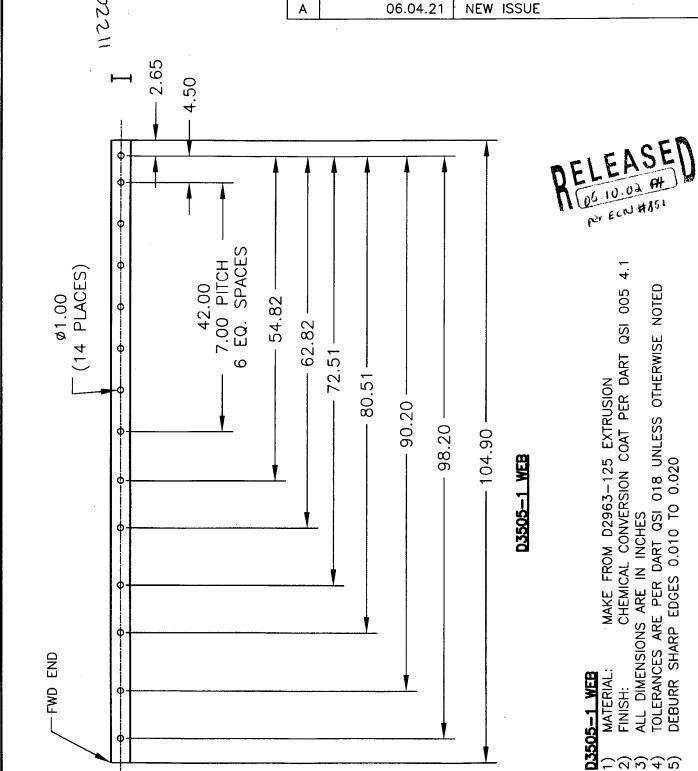
Comments:

IPP Rev:A New Issue 06-05-30 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<b>D2963-125</b> 105 I Beam Extrusion		Manufactured	No			120	Each	34.0000	1	10			
20012000				<b>Location</b>		Loc Qty	<u>Lo</u>	c Code					
				HALL Q86	72	34 34				0)	14-02-25	5 DGC	

DQA:			Date:						_					•	TRAG
						WORK ORDER NON-CONFORMANCE / UPDATE									
QA Closed:			Date:			Work Order update only									
Work Order:						DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	_				<del></del>	Rework			Skid-tube Crosstube			Water Jet			Engineering
Part N	lo					Scrap	]	Machining Small Fab				Prod. Eng. Coor.		Quality	
						Use-as-is	Thermoforming Finishing			Re	Rec/Store/Packaging			Other	
NCR N	۱٥					Suspected Unapproved	Suspected Unapproved Large Fab Composite			Composite	Supplier				
Root					Desc	ription of work order update	Π	Initial	Act	ion	Sign	ո &			
Cause		Date	Step	Qty		or non-conformance	Ch	nief Eng	Descr	ription	Da	te	Verificatio	n	QC Inspector
Design											Ì				
Doc/Data															
Equip/Tooling											1				
Handling/Pre															
Material															
Operator	_										Í				
Offset/Setup							Ì				ļ				
Process	$\vdash$														
Supplier	_														
Training															-#
Transport					ì								:		
Unapproved							1								
							FA	ULI CA	TEGORY						
Landii	$\overline{}$					General		]		Г	٠	l. 5'			,
	Bending			Bend	-	-1	Program			Outside Dimensions			Pressure/Forced		
	Centre Not Concentric			BOM/Route	-	Grain	-			Over/Under tolerance			Set-up		
	Cracks			Broken/Damage/Defect	$\vdash$	Hardwa				Part Incorrect			Temperature/Cure		
	Crimp/Kink/Ripple/Wave				Burrs	$\vdash$	Inspection Incomplete/Unqualified Instructions Incomplete/Unclear		· -		Part Lost/Missing		Weld		
	Cuffs				Countersink	-	-	-	Jinclear			L	Wrong Stock Pulled		
	Crushing				Countersink Cut Too Short	-	ન ે	gned/off center	}	Positioned Wrong Power Loss/Surge			Other		
	Heat Treat				Drawing	$\vdash$	Mislabeled Misread			LU35/	Juige	Щ	Otilei		
	Inspection Strip in Tube  Marks/Chatter				$\vdash$	Drill Holes	$\vdash$	Off-set							
	-	· ·			-	Finish	$\vdash$	-	Calibration						
	Turning Sequence Wave/Twist in Tube				$\vdash$	Fit/Function	-	Out of Sequence							





Copyright © 2006 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

	The state of the s				1 3
r**					
					!
					1
-					
2					
					· · · · · · · · · · · · · · · · · · ·
					· ·
					1
		• •			
				·	
				•	: :
					; · · · ·
			•		-
2007. 6	* *				
		•			
š					
₹ ~ .*					
	<b>.</b>				<b>1</b>

----